

84512

Page 1

Accept

N900040100

Setup Start: *NS1*

Stop *NS2*

Cust Item ID:

*** 1 ***

Required Date: 06/06/2012 **Req'd Qty:** 1.00

* 1 *

Customer:

Reference:

Approvals:

Process Plan: M, J

Date: 12/05/15

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84512

84512

Page 2

May-15-12 10:38:30 AM

Item ID: D3391-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Tube Assembly
 Start Date: 15/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 06/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>1</u> & Dwg D3391 Rev. <u>1</u> Identify as D3391-1 2-Deburr	0.00 0.00	<u>2</u>	<u>126-3</u>		<u>1</u>	<u>4</u>		
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<u>2</u>	<u>12-6-3</u>		<u>1</u>	<u>4</u>		
150 *150* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1-Drill .1875" at end of tube as per Dwg D3391	0.00 0.00	<u>end</u>	<u>12/06/05</u>		<u>1</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
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May-15-12 10:38:30 AM

84512

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 06/06/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC2- Inspect parts off machine FAI/FAIB

0.00

160

QC

Memo

0.00

Quality Control

170

QC8- Inspect parts - second check

0.00

170

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
180									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (DRILL ALL HOLES)								
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step								
	3-Open tow cap holes to .208" as per Dwg D3391								
	4-Open Tow Ring hole to .640" as per Dwg D3391								
	5-open float bag holes 0.328" and counter sink as per dwg D3391								
	6-Deburr and scribe batch # inside aft end								
	7- transfer drill D3391-011 with D3391-013 - Re 12/06/06								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

CF 12.6.5

Schubert

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							DC 12/06/06
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							① SAD 12-06-06
220 *220* Skidtubes Skidtubes	Skidtubes Memo 1-Install crossbolt spacers per dwg D3391 A/R Magnabond 6398 batch: <u>M120666</u> 2- Grind flush 3- back drill crossbolt if necessary	0.00 0.00							- DC 12/06/06 DC 12/06/06

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

230									
QC	Memo	0.00							

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

235	Pressure Wash per QSI005 4.3	0.00							
-----	------------------------------	------	--	--	--	--	--	--	--

235									
HandFinish	Memo	0.00							

Hand Finishing	AND REALODINE AS PER PAR09-043								
----------------	--------------------------------	--	--	--	--	--	--	--	--

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

240									
Powdercoat	Memo	0.00							

Powder Coating	START TIME: 3:15								
----------------	------------------	--	--	--	--	--	--	--	--

OVEN TEMPERATURE: 3200 F

FINISH TIME: 3:45

ml21134

1 7/6 12-6-7

IX 0 M-L 12/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 7

0.00

8/17/2012

1 x d H 1206113

1 x 6 98 210613

W/O:		WORK ORDER CHANGES					
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Work Order ID 84512

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 Required Date: 06/06/2012 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00		D412-742-041/384522		1x	0	Unloading	
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/6/12 MR 12-06-12

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-15-12 10:38:34 AM

Page 1

Work Order ID: 84512

84512

Parent Item: D3391-011

D3391-011

Parent Item Name: Fwd Tube Assembly

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.09.13 New issue KJ/JLM
 IPP B06.02.09 Dwg rev.D EC
 IPP C 07.03.13 revF dwg ec
 IPP D 07.11.01 ecn1053P EC
 IPP Rev:E ECN 1056 07-11-12 DD verified by:EC
 IPP Rev:F 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 10.04.07 add part in bom DD verified by:JLM IPP Rev:I 11.11.14 AS
 PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-051 *D4095-051* Wearpad Assembly		Manufactured	No			255	Each	25.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		25							
				78914		3							
				<u>81613</u>		22							
D6013-047 *D6013-047* Skidtube Material		Manufactured	No			100	Each	94.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		94							
				<u>72505</u>		94							
D3401-041 *D3401-041* Tow Cap Assembly		Manufactured	No			255	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		13							
				78990		1							
				82302		12							

**

12/06/13

**

Dec 12/05/22

**

B83432 (x1) 12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-15-12 10:38:34 AM

Page 2

Work Order ID: 84512

84512

Parent Item: D3391-011

D3391-011

Parent Item Name: Fwd Tube Assembly

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

89.0000

9

9

D3670-4-200

SPACER

**

12C 12/06/06

Location

B84504

Loc Qty

Loc Code

LG

40

80360

40

LG001

49

81972

49

9

D3672-1

Manufactured No

255

Each

1,214.000

4

4

D3672-1

Phenolic Washer

**

12/06/13

Location

Loc Qty

Loc Code

ST060

1214

72229

4

76277

210

80369

500

83608

500

✓

AN3C4A

Purchased No

255

Each

1,969.000

10

10

AN3C4A

BOLT

**

12/06/13

Location

Loc Qty

Loc Code

ST350

1969

120187

63

120521

28

120769

38

121205

1000

121556

840

✓

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

***AN960C10L ***

washer

**

11/21/509 (via) 12/06/13

May-15-12 10:38:34 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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May-15-12 10:38:34 AM

Page 3

Work Order ID: 84512

84512

Parent Item: D3391-011

D3391-011

Parent Item Name: Fwd Tube Assembly

Start Date: 15/05/2012

Required Date: 06/06/2012

Start Qty: 1.00

Required Qty: 1.00

AEELS-1032-225

Purchased

No

255

Each

0.0000

10

10

AFI S-1032-225 X AHS4-1032-225

**

M121269 (10x) H 12/06/13

INSERT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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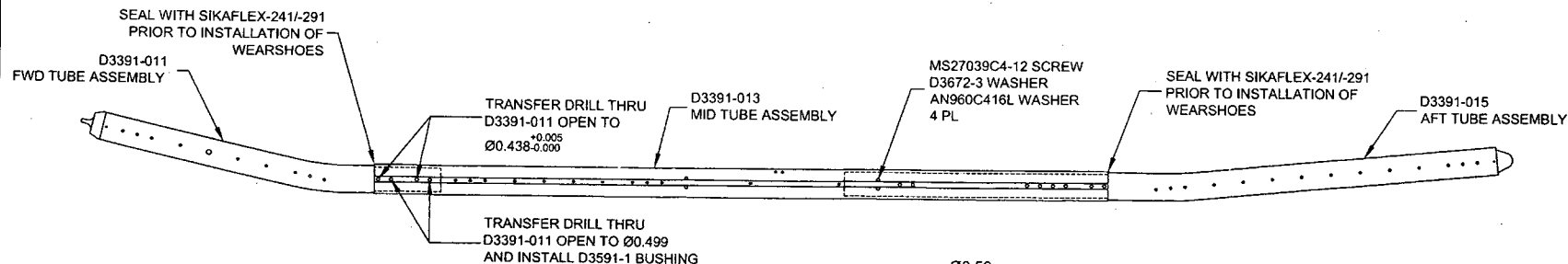
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D3391-041 ASSEMBLY

WITHOUT NOTICE
WORK ORDER
NO. 84512 MCT
12/05/15

RELEASED
2011-11-04
ECN# 11-662

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1). FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2). COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3). TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4). UNITS: INCHES UNLESS OTHERWISE NOTED
- 5). USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6). FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7). FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

REV.	DESCRIPTION	BY	DATE
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
DESIGN	PH	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO. D3391	REV. 1 SHEET 1 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		412 FLOAT SKIDTUBE	NTS
DE APPR.			
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

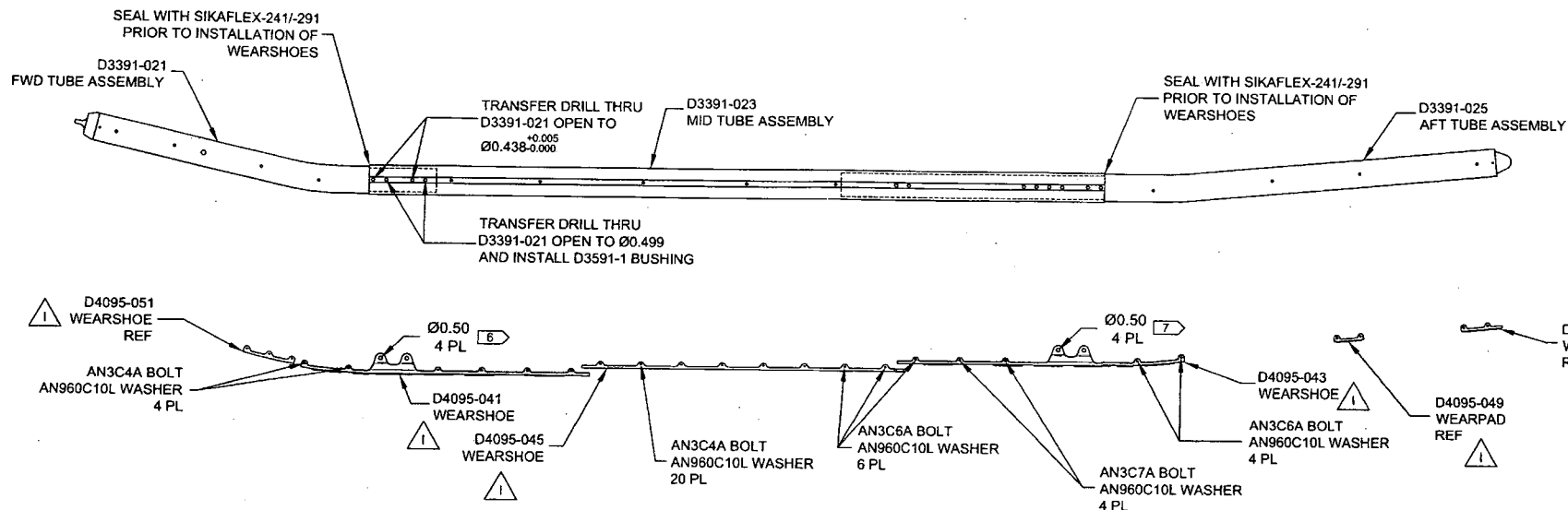
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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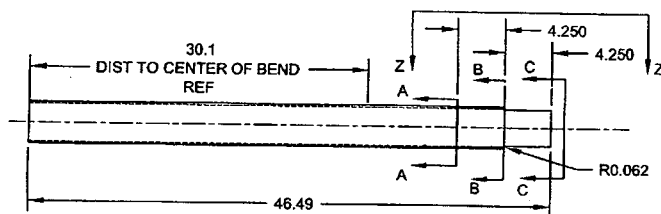
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

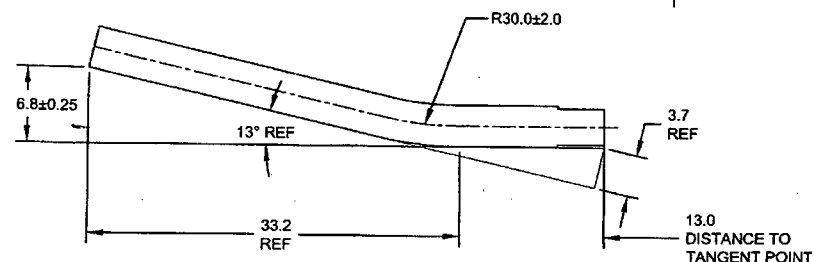
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

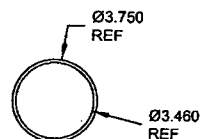
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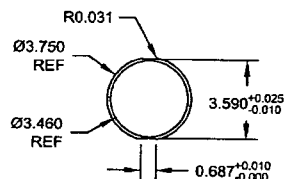
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



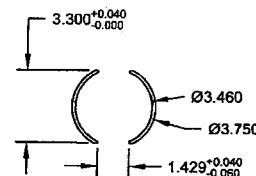
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



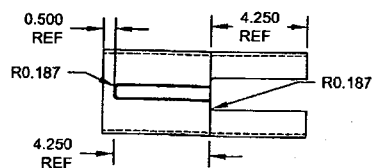
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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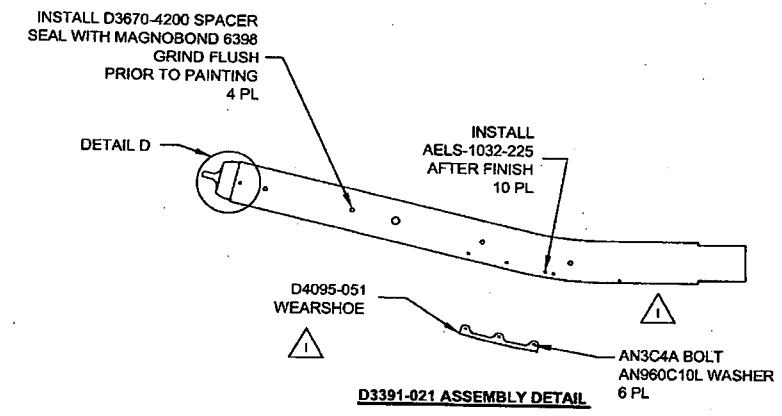
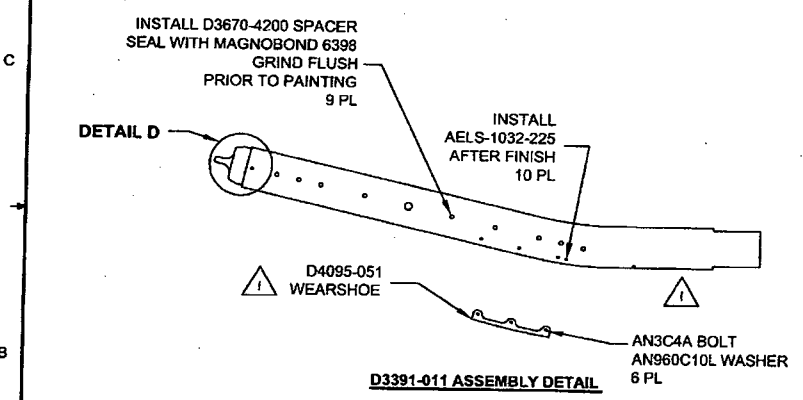
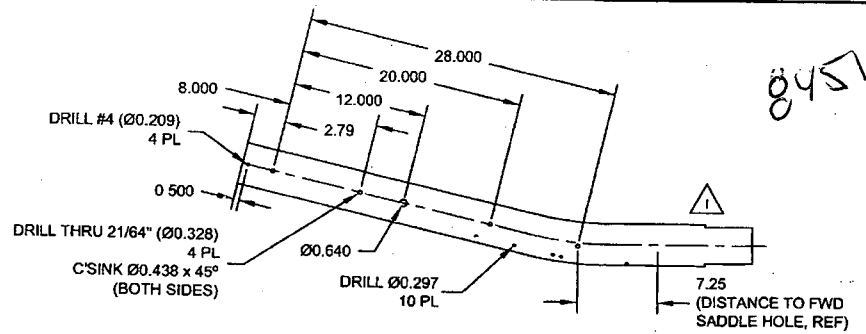
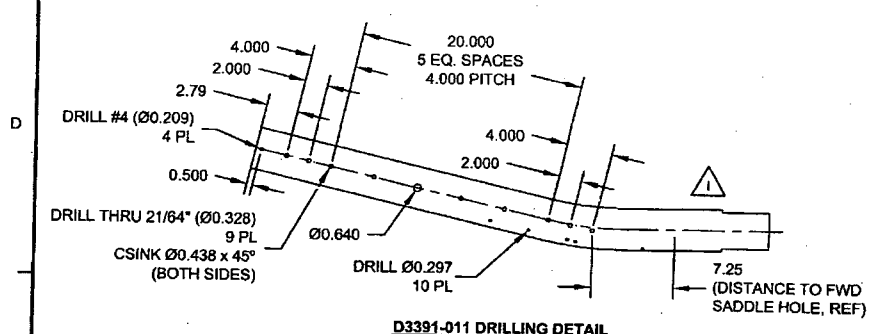
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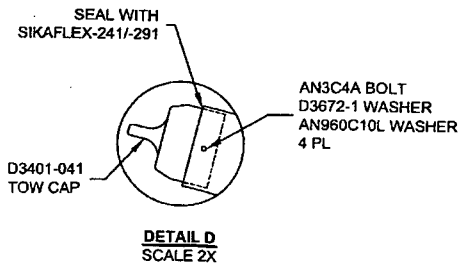
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84512



D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



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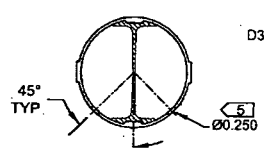
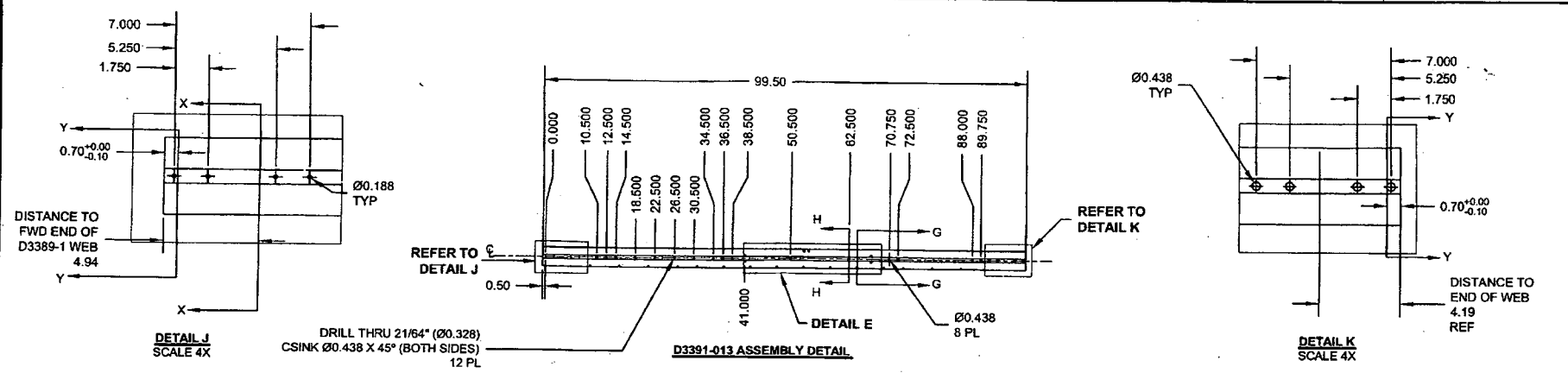
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

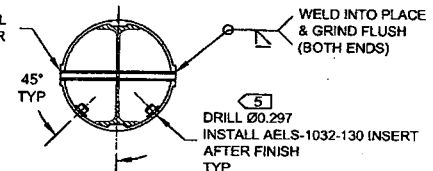
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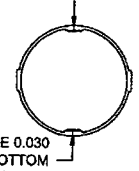
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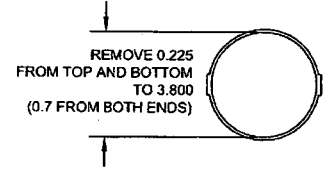
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



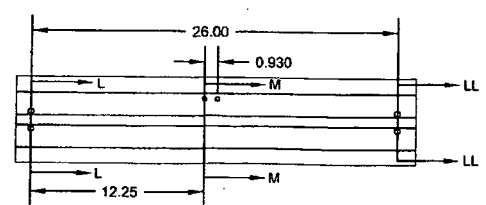
SECTION X-X
SCALE 5X



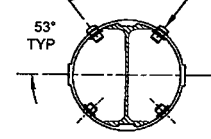
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

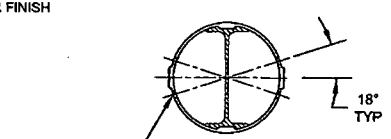
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN980C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



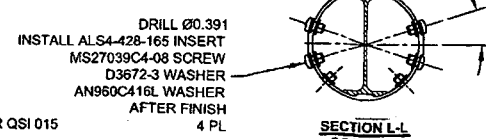
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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8 7 6 5 4 3 2 1

7.000
5.250
1.750

0.70^{+0.00}_{-0.10}

Ø0.188 TYP

DISTANCE TO FWD END OF D3389-1 WEB 4.94

Y

X

DETAIL J
SCALE 4X

10.500

REFER TO DETAIL J

0.50

22.500

36.500

50.500

62.500

70.750

72.500

88.000

89.750

91.500

99.50

H

G

H

G

Ø0.438 8 PL

REFER TO DETAIL K

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
5 PL

D3391-023 ASSEMBLY DETAIL

7.000
5.250
1.750

0.70^{+0.00}_{-0.10}

Y

Y

DISTANCE TO END OF WEB 4.19 REF

DETAIL K
SCALE 4X

45° TYP

Ø0.250

SECTION G-G
SCALE 5X

INSTALL D3681-1 SPACER

45° TYP

WELD INTO PLACE & GRIND FLUSH (BOTH ENDS)

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
AFTER FINISH TYP

SECTION H-H
SCALE 5X

5 PL

REMOVE 0.030
FROM TOP AND BOTTOM
TO 3.610

SECTION X-X
SCALE 5X

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015

3) WELDING: PER DART QSI 004

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DRAWN XDF
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MFG. APPR.
APPROVED
DE APPR.
DATE 11.10.13

DART AEROSPACE USA, INC
KENT, WA

DRAWING NO. D3391

TITLE 412 FLOAT SKIDTUBE

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8 7 6 5 4 3 2 1

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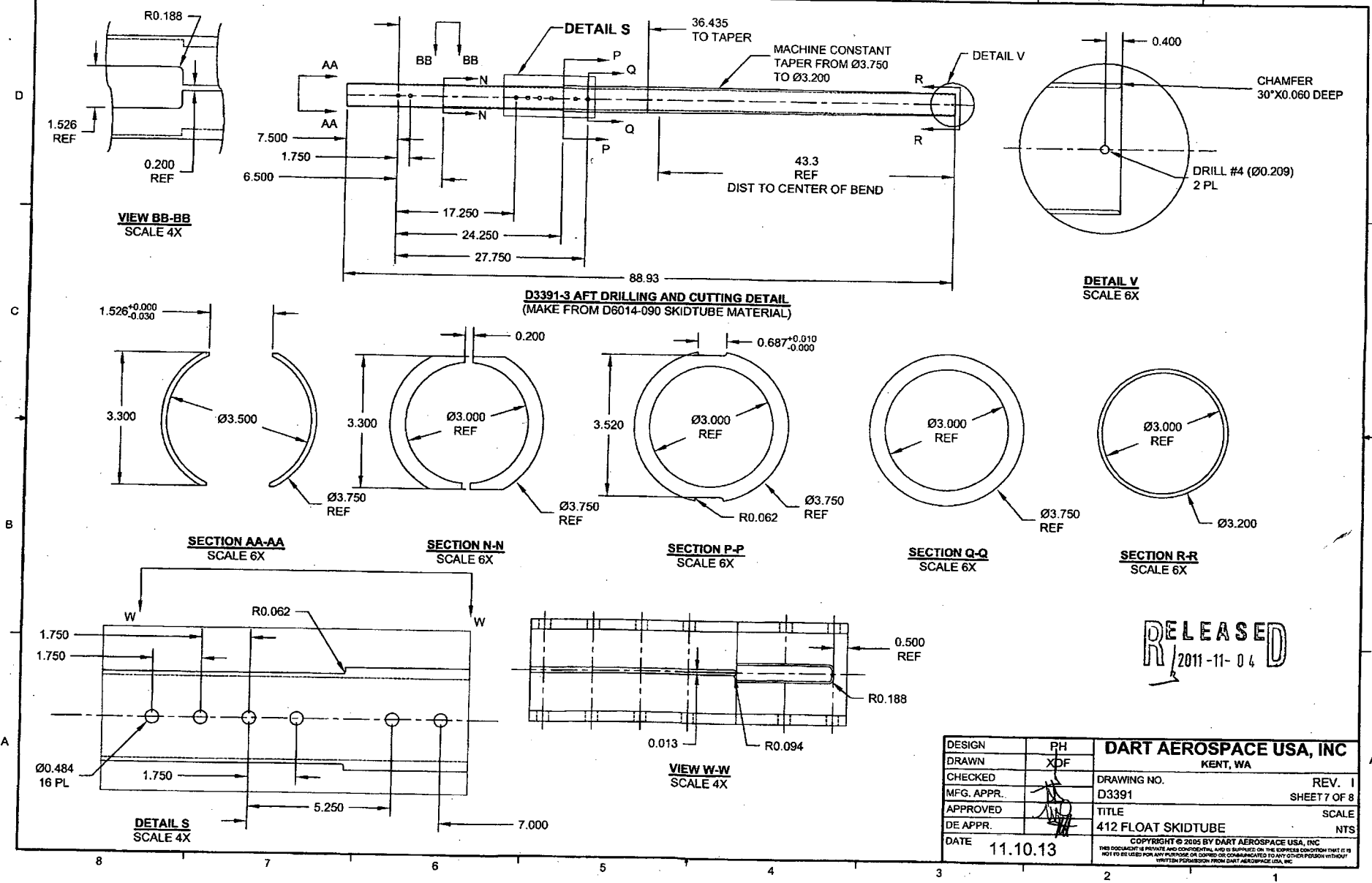
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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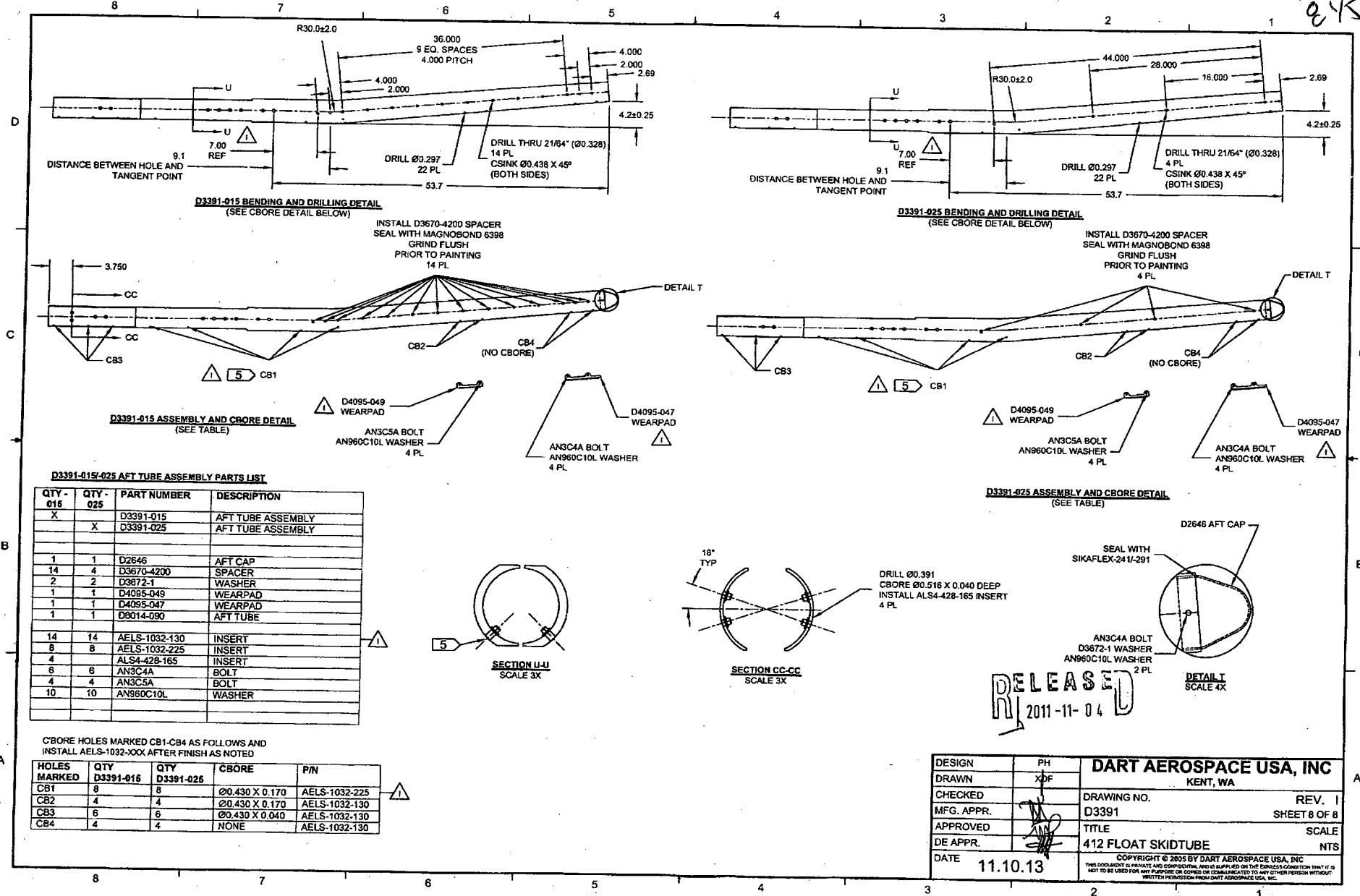
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24512



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